

Work Order ID 112714

Wednesday, February 05, 2014 2:59:32 PM

112714

Page 1

Item ID: D119-646-213 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube with Run-On Landing Wearplates LH Apical Float Compatible
 Start Date: 2/5/2014 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 2/14/2014 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: 10 Date: 1/10/25 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D119-646	B

MCS JUN 17 2015

100 0.00
 100
 DC

Document Control Memo 0.00
 Photocopy bluefile & type labels per PPP D119-646-213
 CHG 004 005 per ECN 14628

110 Pick Kit 0.00
 110
 Packaging Memo 0.00

Packaging

120 QC4- 100% Inspect kits for completeness 0.00
 120
 QC Memo 0.00

Quality Control

B114947LH

Work Order ID 112714

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Item ID: D119-646-213

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube with Run-On Landing Wearplates LH Apical Float Compatible

Start Date: 2/5/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/14/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									DAS
Packaging	Memo	0.00							02
Packaging	Identify and pack for shipping as per PPP D119-642-213								9-89
	Location: <u>offshore</u>								
	PPP rev: <u>114947</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									JUN 17 2015
QC	Memo	0.00							
Quality Control									

JUN 18 2015**JUN 17 2015**

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 112714

112714

Parent Item: D119-646-213

D119-646-213

Parent Item Name: Skidtube with Run-On Landing Wearplates LH Apical Float Compatible

Start Date: 2/5/2014

Required Date: 2/14/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
12.09.12 as per ECN12-644 DD verf:JLM IPP Rev:B
raise to chg003 (ECN 12-675) DD verf:JLM IPP REV:C 12.11.05
chg004 (ECN 13-534) DD verf:JLM IPP REV:D 13.03.20 raise to

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D119-646-243

Manufactured No

110

Each

3.0000

1

D119-646-243

Replacement Skidtube with Run-On Wearplates Apical Float Compatible (Fits LH or RH)

DAS
6
9-89

Location

Loc Qty

Loc Code

FG
102699
108743
FG073
102702

2
1
1
1
1

**

DAS
02
9-89

JUN 17 2015

D119-646-311

Manufactured No

110

Each

4.0000

1

D119-646-311

Ground Handling

DAS
31
9-89

Location

Loc Qty

Loc Code

PKG013
101048
101768

4
1
3

**

113806

DAS
33
9-89

D3883-1

Manufactured No

110

Each

8.0000

2

D3883-1

Saddle, Outboard LH

DAS
31
9-89

Location

Loc Qty

Loc Code

ST439A
101055
105145

8
7
1

**

113812

DAS
33
9-89

14-04-29

Picklist Print

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Work Order ID: 112714

112714

Parent Item: D119-646-213

D119-646-213

Parent Item Name: Skidtube with Run-On Landing Wearplates LH Apical Float Compatible

Start Date: 2/5/2014

Required Date: 2/14/2014

Start Qty: 1.00

Required Qty: 1.00

D3884-1

Manufactured No

110

Each

10.0000

D3884-1

Saddle, Inboard LH

**

2

113601

DAS
33
9-89



Location

Loc Qty

Loc Code

ST439A

10

101517

3

105146

2

110892

4

112248

1

DAS
31
9-89

D2652

Manufactured No

110

Each

657.0000

D2652

Bushing

**

16

16

113196

DAS
33
9-89



Location

Loc Qty

Loc Code

FG

44

31985

44

ST014

613

103022

198

103643

201

106590

14

110800

200

DAS
31
9-89

AN3C50A

Purchased No

110

Each

131.0000

AN3C50A

Bolt

**

8

8

DAS
33
9-89

14-04-29



Location

Loc Qty

Loc Code

ST512

131

M126007

131

DAS
31
9-89

126007

Picklist Print

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Work Order ID: 112714

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Parent Item: D119-646-213

D119-646-213

Parent Item Name: Skidtube with Run-On Landing Wearplates LH Apical Float Compatible

Start Date: 2/5/2014

Required Date: 2/14/2014

Start Qty: 1.00

Required Qty: 1.00

AN4C6A	Purchased	No	110	Each	317.0000	18	18	DAS
AN4C6A						**	128324	33
Bolt								9-89

DAS
S1
9-89

Location

Loc Qty

Loc Code

FG	14	
103344	4	
121657	10	
ST355	303	
m125709	303	

MS21250-05-006

Purchased

No

110

Each

91.0000

8 8

MS21250-05-006

BOLT

**

128431

DAS
33
9-89

Location

Loc Qty

Loc Code

FG	5	
124291	5	
ST320	11	
125388	11	
st507	75	
124751	75	

DAS
S1
9-89

NAS1149C0332R

Purchased

No

110

Each

9,652.000

17

NAS1149C0332R

WASHER

**

128591

DAS
33
9-89

14-0429

Location

Loc Qty

Loc Code

GA	1169	
125654	1169	
st510	8483	
m126319	865	
m127306	2500	
m127410	3000	
m127831	2118	

DAS
S1
9-89

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Parent Item: D119-646-213

D119-646-213

Parent Item Name: Skidtube with Run-On Landing Wearplates LH Apical Float Compatible

Start Date: 2/5/2014

Required Date: 2/14/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

110

Each

5,020.000

30

30

NAS1149C0432R

WASHER

DAS
S1
9-89

Location

Loc Qty

Loc Code

GA

1975

m125807

1975

ST292

68

119124

6

121255

7

122441

55

ST510a

2977

m126221

2977

**

DAS
33
9-89

NAS1149C0532R

Purchased

No

110

Each

440.0000

8

8

NAS1149C0532R

WASHER

DAS
S1
9-89

Location

Loc Qty

Loc Code

GA

55

116513

55

ST292

385

m126319

385

**

DAS
33
9-89

MS21043-3

Purchased

No

110

Each

655.0000

8

8

MS21043-3

Nut

DAS
S1
9-89

Location

Loc Qty

Loc Code

FG

80

103691

80

ST315

575

124555

71

m126741

504

**

DAS
33
9-89

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Work Order ID: 112714

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Parent Item: D119-646-213

D119-646-213

Parent Item Name: Skidtube with Run-On Landing Wearplates LH Apical Float Compatible

Start Date: 2/5/2014

Required Date: 2/14/2014

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

365.0000

13

13

DAS

33

9-89

MS21043-4

Nut

**

128300

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

41

125807

41

ST509

284

m127255

284

DAS

31

9-89

D2712

Manufactured

No

110

Each

434.0000

12

12

DAS

33

9-89

D2712

Set Screw

**

113205

Location

Loc Qty

Loc Code

FG

50

29962

50

ST017

384

101775

190

107365

2

108882

42

110809

150

DAS

31

9-89

D3672-7

Manufactured

No

110

Each

1,113.000

24

24

**

140429

D3672-7

Phenolic Washer

DAS

33

9-89

Location

Loc Qty

Loc Code

FG

25

93370

25

ST060

1088

101752

47

103641

541

111568

500

DAS

31

9-89

103641

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Work Order ID: 112714

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Parent Item: D119-646-213

D119-646-213

Parent Item Name: Skidtube with Run-On Landing Wearplates LH Apical Float Compatible

Start Date: 2/5/2014

Required Date: 2/14/2014

Start Qty: 1.00

Required Qty: 1.00

D3672-3

Manufactured No

110

Each

575.0000

30

30

D3672-3

Phenolic Washer

**

113746

DAS

33

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

FG

111

84432

11

89273

100

FP001

63

107316

63

ST060

400

110251

400

ST061

1

93925

1

D3407-041

Manufactured No

110

Each

26.0000

1

1

D3407-041

Tow Ring

**

112247

DAS

33

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

ST444

3

107840

3

ST463

23

107954

3

109405

8

110069

4

110684

8

D3417-5

Manufactured No

110

Each

159.0000

1

1

D3417-5

Washer

**

DAS

33

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

ST042

159

106851

46

109747

13

109907

100

106851

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Shop Packet Print

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Picklist Print

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Work Order ID: 112714

112714

Parent Item: D119-646-213

D119-646-213

Parent Item Name: Skidtube with Run-On Landing Wearplates LH Apical Float Compatible

Start Date: 2/5/2014

Required Date: 2/14/2014

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Manufactured No

110

Each

171.0000

1

1

D3456-1

Washer

**

113 126

DAS
33
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

FG	7	
25701	7	
ST046	164	
103787	22	
107629	17	
111514	25	
111782	100	

D3417-7

Manufactured No

110

Each

52.0000

1

1

D3417-7

Washer

**

DAS
33
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST042	52	
102368	45	
91553	7	

102368

NAS1149D0463J

Purchased No

110

Each

6,417.0000

6

6

NAS1149D0463J

WASHER

**

128591

DAS
33
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST294	2017	
M127693	2017	
ST510a	4400	
M127813	1400	
M127904	3000	

DAS
02
9-89

DAS
6
9-89

1 x DSI 9685.011

B12938

per ECN 14-628

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DART AEROSPACE USA, INC.

REFERENCE ONLY

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DAS
31
9-09

14-05-02

4.3 Float Skidtubes

Item	Qty -013	Qty -014	Qty -113	Qty -114	Qty -213	Qty -214	Qty -043	Qty -143	Qty -153	Qty -243	Qty -253	Qty -311	Part Number	Description
	X												D119-646-013	FLOAT SKIDTUBE INSTALLATION WITH WEARPADS, LH
		X											D119-646-014	FLOAT SKIDTUBE INSTALLATION WITH WEARPADS, RH
			X										D119-646-113	FLOAT SKIDTUBE INSTALLATION WITH FULL LENGTH WEARPLATES & WEARPADS, LH
				X									D119-646-114	FLOAT SKIDTUBE INSTALLATION WITH FULL LENGTH WEARPLATES & WEARPADS, RH
					X								D119-646-213	FLOAT SKIDTUBE INSTALLATION WITH TRAINING WEARPLATES, LH
						X							D119-646-214	FLOAT SKIDTUBE INSTALLATION WITH TRAINING WEARPLATES, RH
	1	1					X						D119-646-043	REPLACEMENT FLOAT SKIDTUBE WITH WEARPADS
			1	1				X					D119-646-143	REPLACEMENT FLOAT SKIDTUBE WITH FULL LENGTH WEARPLATES & WEARPADS
									X				D119-646-153	WEARPLATE KIT STANDARD SKIDTUBE
										X			D119-646-243	REPLACEMENT FLOAT SKIDTUBE WITH TRAINING WEARPLATES
											X		D119-646-253	TRAINING WEARPLATES FLOAT SKIDTUBE
	1	1	1	1								X	D119-646-311	GROUND HANDLING KIT
1							1						D3905-041	FLOAT SKIDTUBE ASSY. WITH WEARPAD
20								1					D3905-043	FLOAT SKIDTUBE ASSY. WITH WEARPLATE & WEARPAD
24									1				D3846-1	GASKET
25									1				D3846-11	GASKET
26									1				D3847-043	FWD WEARPLATE ASSY
27									1				D3847-045	CENTER WEARPLATE ASSY
28									1				D3847-049	AFT WEARPLATE ASSY
29									8				D3847-1	WEARPAD
30									1				D3847-11	WEARPAD
31									42				AN3C5A	BOLT
32									42				AN960C10L	WASHER (OR NAS1149C0332R)
40										1			D3905-045	FLOAT SKIDTUBE ASSY. TRAINING WEARPLATE
44											1		D3849-047	FWD TRAINING WEARPLATE ASSY
45											1		D3849-045	AFT TRAINING WEARPLATE ASSY
46											1		D3846-1	GASKET
47											1		D3846-11	GASKET
48											1		D3847-1	WEARPAD
49											1		D3847-11	WEARPAD
51											16		D3904-1	WASHER
52											8		AN3C46A	BOLT
53											8		MS21043-3	NUT
54											10		AN3C5A	BOLT
55											10		AN960C10L	WASHER (OR NAS1149C0332R)
60	2		2		2								D3883-1	SADDLE, OUTSIDE, LH
61		2		2		2							D3883-2	SADDLE, OUTSIDE, RH
62	2		2		2								D3884-1	SADDLE, INSIDE, LH
63		2		2		2							D3884-2	SADDLE, INSIDE, RH
64	16	16	16	16	16	16							D2652	BUSHING
65	8	8	8	8	8	8							AN3C50A	BOLT
66	12	12	12	12	12	12							AN4C6A	BOLT
67	8	8	8	8	8	8							MS21250-05006	BOLT
68	8	8	8	8	8	8							AN960C10L	WASHER (OR NAS1149C0332R)
69	24	24	24	24	24	24							AN960C416L	WASHER (OR NAS1149C0432R)
70	8	8	8	8	8	8							AN960C516L	WASHER (OR NAS1149C0532R)

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Revision: B
 Date: 09.06.29

REFERENCE ONLY

DART AEROSPACE USA, INC.

DAS
31
9-09

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Item	Qty -013	Qty -014	Qty -113	Qty -114	Qty -213	Qty -214	Qty -043	Qty -143	Qty -153	Qty -243	Qty -253	Qty -311	Part Number	Description
71	8	8	8	8	8	8							MS21043-3	NUT
72	12	12	12	12	12	12							MS21043-4	NUT
73	12	12	12	12	12	12							D2742	SET SCREW
74	16	16	16	16	16	16							D3672-7	WASHER
75	24	24	24	24	24	24							D3672-3	WASHER
76	8	8	8	8	8	8							D3672-7	WASHER
80	1	1	1	1	1	1							D3407-041	TOW RING
81	1	1	1	1	1	1							D3417-5	WASHER
82	1	1	1	1	1	1							D3456-1	WASHER
83	1	1	1	1	1	1							MS21043-4	NUT
84	1	1	1	1	1	1							D3417-7	WASHER
90												2	D3886-041	LUG ASSEMBLY
91												8	D2652	BUSHING
92												4	AN3C46A	BOLT
93												4	AN980C10L	WASHER (OR NAS1149C0332R)
94												4	MS21043-3	NUT
100	3	3	3	3									AN3C45A	BOLT
101					(3)	(3)							AN3C50A	BOLT
102	3	3	3	3									AN3C45A	BOLT
103					(3)	(3)							AN3C46A	BOLT
104					(9)	(9)							D3904-1	WASHER
105	6	6	6	6	6	6							AN4C6A	BOLT
106	6	6	6	6	6	6							D3672-3	WASHER
107	6	6	6	6	6	6							AN980C416	WASHER (OR NAS1149C0432R)
108	6	6	6	6	6	6							AN980JD416	WASHER (OR NAS1149C0463J)
109	12	12	12	12	(3)	(3)							AN980C10L	WASHER (OR NAS1149C0332R)
110	6	6	6	6	(6)	(6)							MS21043-3	NUT

() ITEMS IN BRACKETS ARE REF. ONLY AND DO NEED TO BE INCLUDED WITH KIT.
AS THEY ARE ALREADY INSTALLED ON SKIDTUBE.

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